

Date: Wednesday, 03/06/2009 7:25:30 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STUD
Job Number	: 48337		
Estimate Number	: 13997		
P.O. Number	:	Part Number	: D39437
This Issue	: 03/06/2009 S.O. No. :	Drawing Number	: D3943 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: A
Previous Run	:	Material	:
Written By	: <u>SA 09-06-03</u>	Due Date	: 10/06/2009
Checked & Approved By	:	Qty:	6 Um: Each
Comment	: Est Rev:A New Issue 09-06-02 JLM Verified By:EC		

Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 M1010R0375 ROUND BAR .375



Comment: Qty.: 0.0294 f(s)/Unit Total: 0.1764 f(s)
 ROUND BAR .375
 BATCH: M110860 10/8

SA 09/06/03

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA825 & DWG D3943,
 FOLIO REV: N/A
 DWG REV: A

2-DEBURR AS REQUIRED

*****TAP DRILL FOR 1/4" 20 IN CENTER OF PART*****

SA 09/06/03

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/06/03

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 09-06-03 (B)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

Dan Skow MF 09-06-03

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STUD

Job Number: 48337

Part Number: D39437

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/04 JF

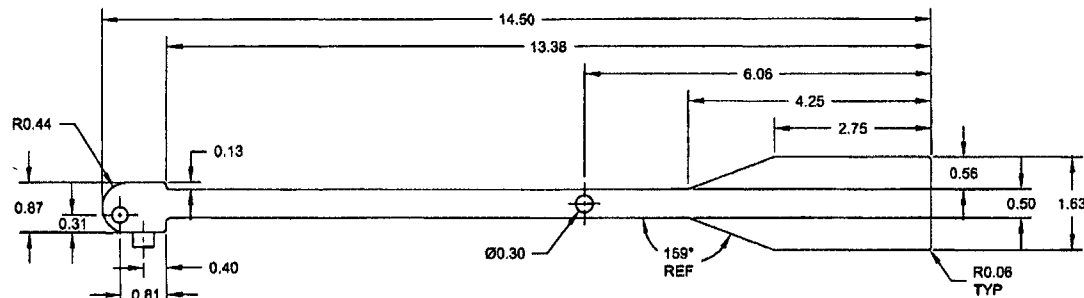
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

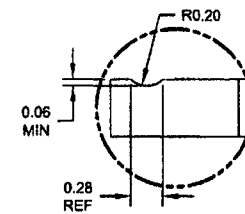


MF
09-06-04

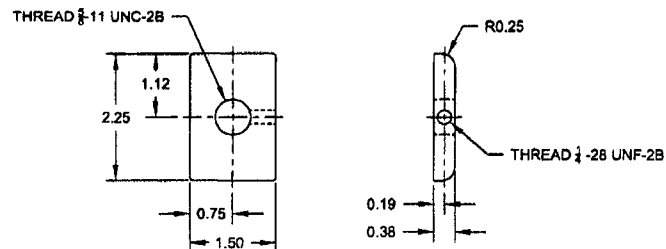
8 7 6 5 4 3 2 1



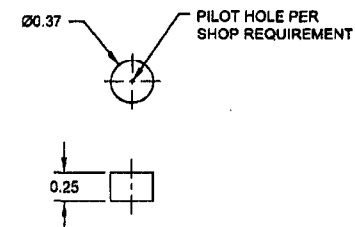
D3943-3 HANDLE EXTENSION



DETAIL B-B
(DIMPLE DETAIL)
(SCALE 2X)



D3943-5 PLATE



D3943-7 STUD
(SCALE 2X)

RELEASED
09/05/13

NOTES -11/-13:

1) MATERIAL -3 & -5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S

OR : MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

-7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

- 2) FINISH -3: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3 PARTS INDICATED
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A

W/O 48337

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3943	REV. A
MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		GROSS WEIGHT TOW CRANK ASSY	SCALE
DE APPR.			NTS
DATE	09.05.13	<small> COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD </small>	

8 7 6 5 4 3 2 1